

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027706**Date Inspected:** 07-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Electroslag Weld Excavations

This QA randomly observed ABF/JV welding personnel performing excavation of welds previously Ultrasonic Testing (UT) rejected. Quality Control (QC) Inspector Jesse Cayabyab performed Magnetic Particle (MT) and visual confirmation of excavations. QC observed rejectable indications at the time of testing. Further repair and excavation are required for these welds. Excavations have been recorded and are to be submitted to engineer for further review.

Excavations were recorded as follows:

Weld "S" – Y=5460mm, L=170mm, W=40mm, D=17mm

Weld "S" – Y=2700mm, L=180mm, W=40mm, D=20mm

This QA Inspector performed confirmation Magnetic Particle Testing (MT) of weld repair excavations on two locations on tower electroslag welds. This QA observed no rejectable indications at the time of testing.

Observation of QCUT:

QC Bernard Docena performed Ultrasonic Testing (UT) of the completed welds designated as EWS L. Mr. Docena tested per AWS D1.5 Table 6.4. Testing is currently in-process.

QC John Pagliero performed Ultrasonic Testing (UT) of the completed welds designated as EWS F. Mr. Pagliero

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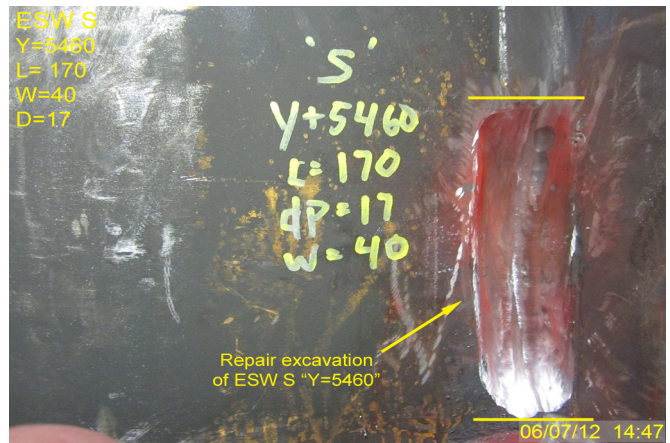
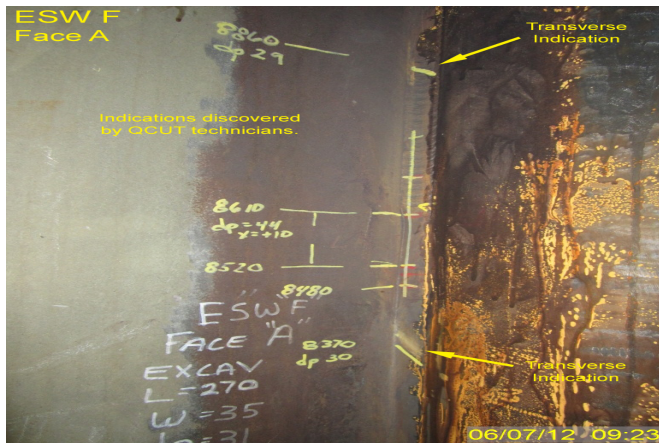
tested per AWS D1.5 Table 6.4. Testing is currently in-process.

QC Andrew Keach performed Ultrasonic Testing (UT) of the completed welds designated as EWS J. Mr. Keach tested per AWS D1.5 Table 6.4. Testing is currently in-process.

Note:

This QA spent a section of this shift reviewing and documenting the status and completion of various punch list items. In addition, this QA collected supporting documentation such as QC Daily and Non Destructive Testing (NDT) reports to be submitted with punch list findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer